

# Work Order ID 68012

Tuesday, April 05, 2011 11:43:45 AM



Page 1

Item ID: D212-664-107TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 11 Date: 11-04-5 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-147	Rev B								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA705  
2-Turn first side as per Folio FA113  
3-File down transition lines smooth.

*JS 11/4/14*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*JS 11/4/14*

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA705  
2-File down transition lines smooth.  
3- Remove plugs and sand

*JS 11/4/14*

*B.A 11/04/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC1- Inspect dimensions to dimension sheet  Memo	0.00  0.00 M.A 11/04/19 11/4/14				1	0		
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00 CRK 11/04/21				1	0		
150  HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion  Memo	0.00  0.00				11	04	28	J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				11-5-4			
170  Packaging Packaging Packaging	Packaging  Memo Identify and stock in kanban rack Location: <u>46</u>	0.00  0.00				11-5-4			
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						11/5/478	

11-05-4

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 05, 2011 11:43:53 AM

Page 1  
1

Work Order ID: 68012



Parent Item: D212-664-107TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD Verified by:ec  
IPP Rev B Removed polish 08.04.02 EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6019-128		Manufactured	No			110	Each	13.0000	1	1			
												4/4/11	

Crosstube Material

Location	Loc Qty	Loc Code
LG	13	
29369	1	
32310	2	
50893	10	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 68012
<b>Description:</b> Crosstube Assembly (205/212/412 Low Fwd)	<b>Part Number:</b> D212-664-147
<b>Inspection Dwg:</b> D212-664-147 <b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.313	+/-0.010	0.305	✓		
	2.360	+0.005/-0.000	2.363	✓		
	2.360	+0.005/-0.000	2.365	✓		
	2.366	+0.005/-0.000	2.370	✓		
	2.473	+0.005/-0.000	2.474	✓		
	2.573	+0.005/-0.000	2.573	✓		
	2.673	+0.005/-0.000	2.676	✓		
	2.750	+0.005/-0.000	2.751	✓		
	2.750	+0.005/-0.000	2.75	✓		
SIDE B	0.313	+/-0.010	0.307	✓	VCCN	GA-01
	2.360	+0.005/-0.000	2.360	✓	"	"
	2.360	+0.005/-0.000	2.365	✓	"	"
	2.366	+0.005/-0.000	2.370	✓	"	"
	2.473	+0.005/-0.000	2.477	✓	"	"
	2.573	+0.005/-0.000	2.573	✓	"	"
	2.673	+0.005/-0.000	2.677	✓	"	"
	2.750	+0.005/-0.000	2.745	✓	"	" ± 0.006
	2.750	+0.005/-0.000	2.751	✓	"	"
		→ ± 0.006				Stock tolerance is ± 0.006 per D6019 11.04.20
	0.126.528	+/-0.020	126.530	✓		

O.K.  
11.04.20

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/4/14	<b>Date:</b> 11/04/21	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.07	New Issue (P/O D212-664-107)	KJ/EC	
B	10.02.02	Dimension 126.528 was 126.53	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Item	Qty -147	Qty -147B	Part Number	Description
1	X		D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
2		X	D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)
3	1	1	D6019-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	2	2	D3659-1	CUFF
7	4	4	MS21920-25	CLAMP (OR MS21920-26)
8	44	44	CR3212-4-05	RIVET (OR M7885/3-4-05)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

# **GENERAL NOTES:**

- MATERIAL: MANUFACTURED FROM D6019-128  
FINISHED LENGTH = 126.528±0.020 (BEFORE BENDING/TRIMMING)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS.
- WEIGHT: D212-664-147 = 24.2 lbs (PER IIN-D212-664)  
D212-664-147B = 24.2 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE
- WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD  
BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%  
BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF  
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.  
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE  
UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS  
NOT BOTTOMED-OUT AFTER TORQUING.
- INSTALL D3659-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF  
SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.  
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68012

DL11-04-5

**RELEASED**  
2009-10-29

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS: ADD -147B (ZN C4-2, D4-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D212-664-147	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE (205/212/412 LOW FWD)	NTS
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DATE	09.09.30		

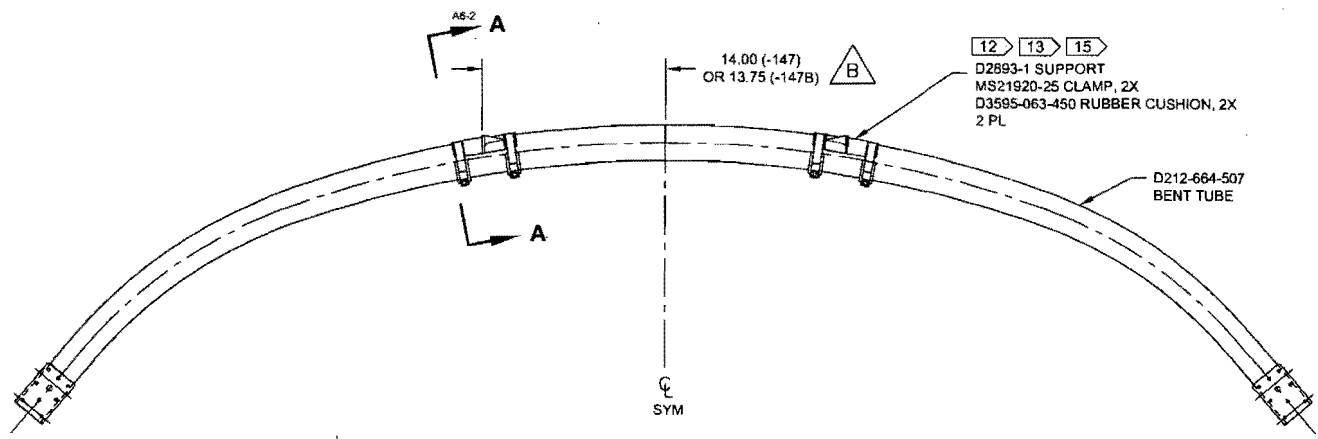
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

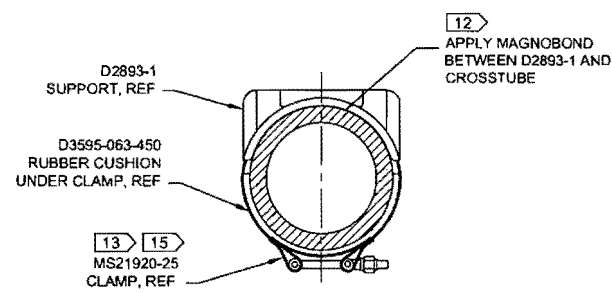
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**D212-664-147/-147B**  
**ASSEMBLY DETAIL** B

*w/o 48012*



**SECTION A-A** D5-2  
SCALE 4X

**RELEASED**  
2009-10-29  
*MD*

DESIGN	<i>90</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>90</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D212-664-147	SHEET 2 OF 4
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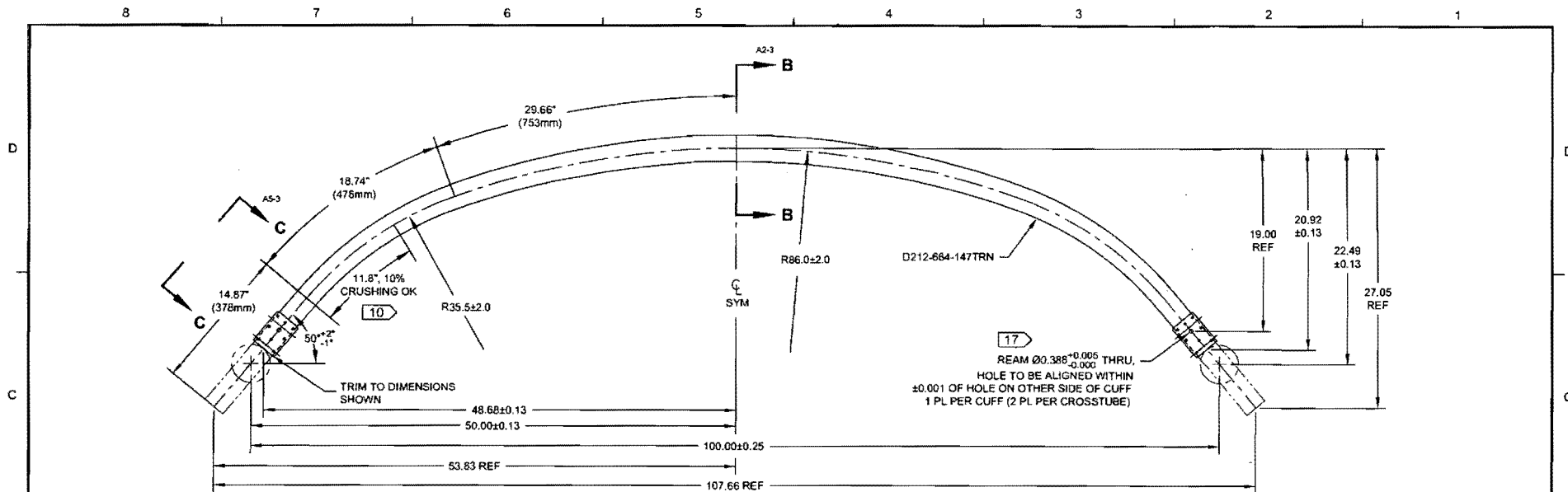
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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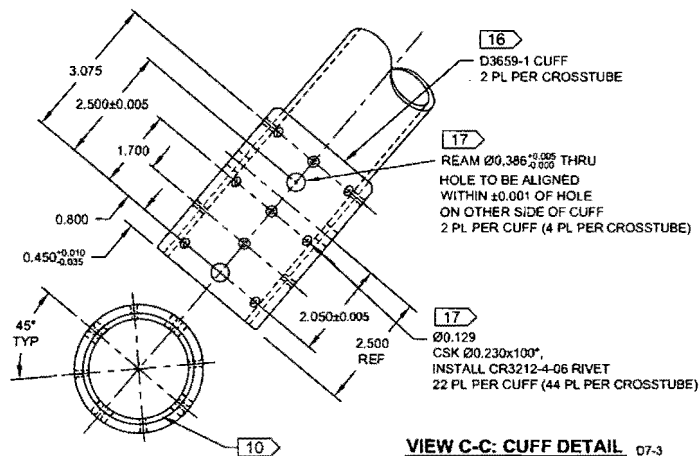
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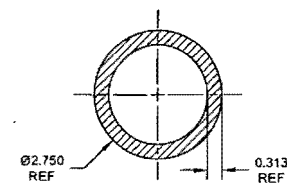


**D212-664-507**  
**BENDING AND DRILLING DETAIL** 10 B

*u/o 68012*



**VIEW C-C: CUFF DETAIL** 07-3  
 SCALE 4X



**SECTION B-B** D5-3  
 SCALE 4X

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 2009-10-29

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MFG. APPR.	RF	D212-664-147	SHEET 3 OF 4
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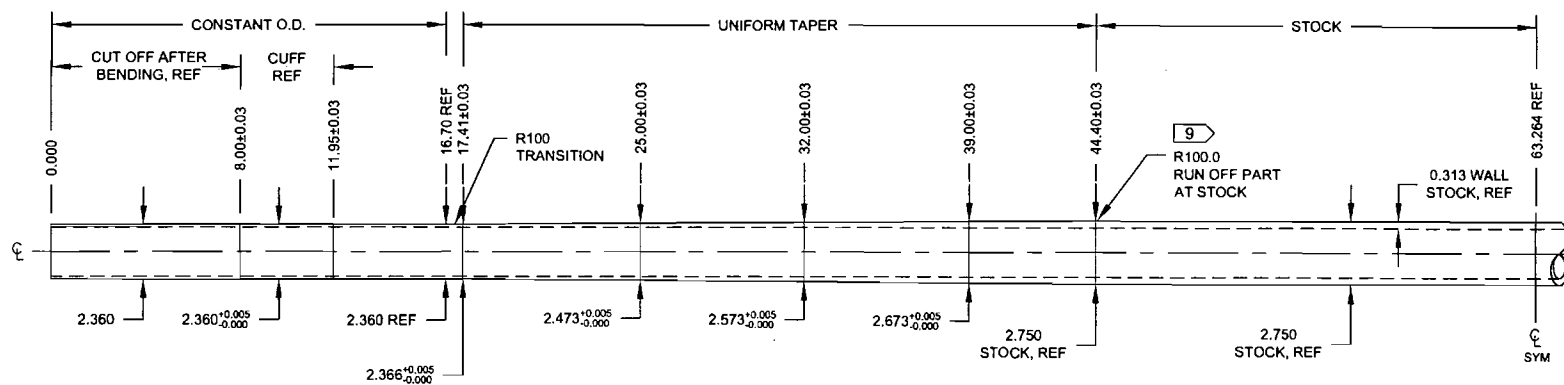
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**D212-664-147TRN**  
**TURNING DETAIL**

W/ 6802

**RELEASED**  
2009-10-29

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	90	DRAWING NO.	REV. B
MFG. APPR.	DS	D212-664-147	SHEET 4 OF 4
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